

split

Date: Wednesday, 09/07/2008 1:19:27 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEM
Job Number : 40403	
Estimate Number : 13457	
P.O. Number :	Part Number : D38031
This Issue : 09/07/2008 S.O. No. :	Drawing Number : D3803 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : PREL
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 16/07/2008
Checked & Approved By : <u>[Signature]</u>	Qty: 40 Um: Each
Comment : Est Rev:A New Issue 08-07-09 JLM Verified By:EC	



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174R0750 Inventory



Comment: Qty.: 0.4725 f(s)/Unit Total: 18.9000 f(s)
M17-4 SS.750" ROUND BAR
BATCH: M107710

20 08/07/13

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA760 Rev prel. & Dwg D3803 Rev prel.

2-Deburr per dwg D3803

20 08/07/13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/07/12 (1)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

03.03.25

P70

ENGINEERING APPROVAL

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

20 05/30

FOR ENGINEERING USE ONLY

POSITIVE RECALL

EFFECTIVE 08/07/09 AUTH 11

RELEASED 11 DATE 08/07/08

only for this I

Customer: CU-DAR001: Dan Helicopters Services

Job Number: 40403

Part Number: D38031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-07-18

DART AEROSPACE LTD		Work Order: 40403
Description: Crosstube Assembly <i>STOMV</i>		Part Number: D3803-1
Inspection Dwg:	Rev: <i>Prelim</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

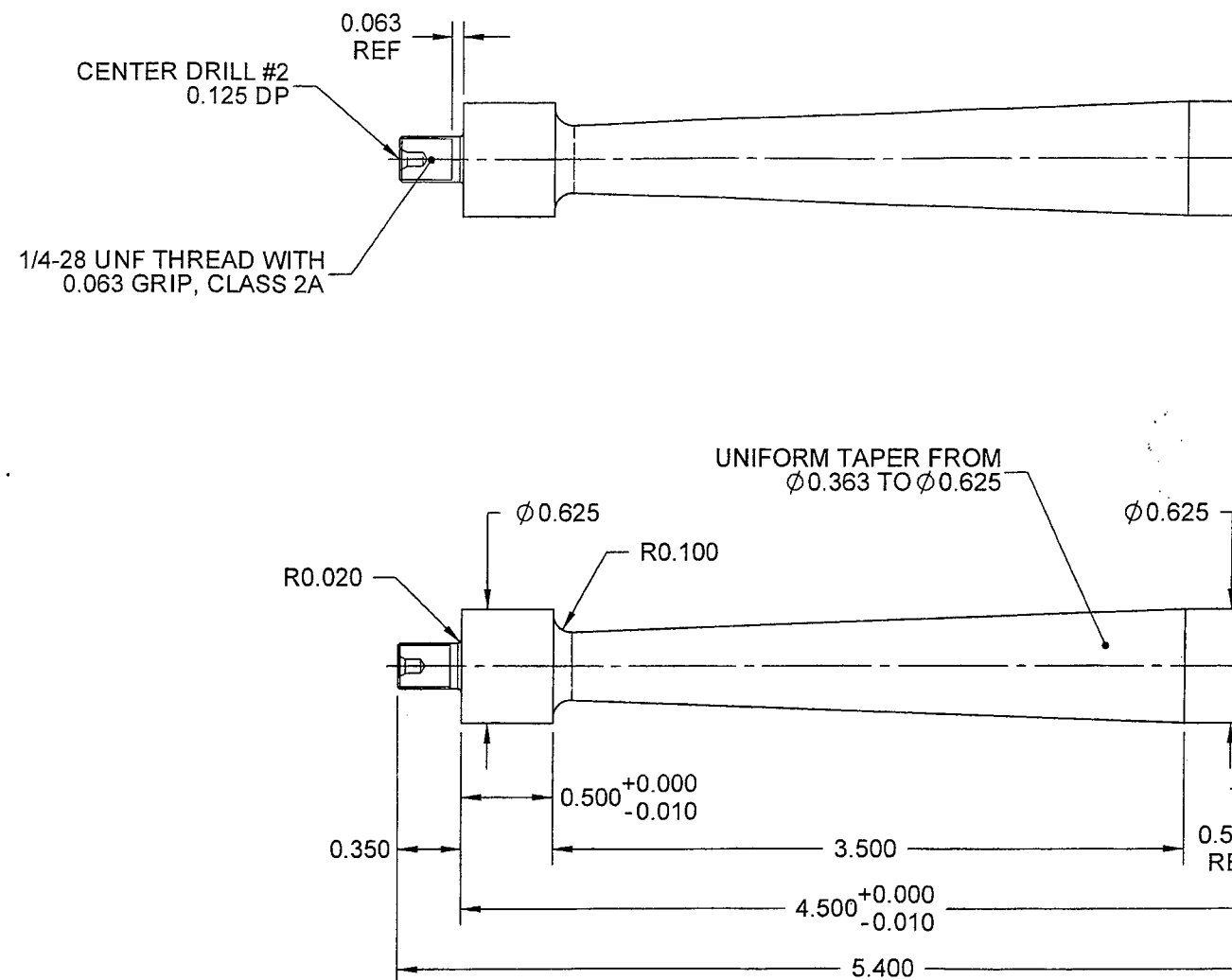
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.063	+/- .010	.063			
	.125	+/- .010	.120			
	1/28 UNF 2A					
	R.020	+/- .010	.015			
	.625	+/- .010	.628			
	R.100	+/- .010	R.100			
	.500	+0.0 - .010	.495			
	.350	+/- .010	.350			
	3.5	+/- .010	3.4			
	4.5	+0 - .010	4.495			
	5.4	+/- .010	5.395			
	.500	+/- .010	.510			
	.625	+/- .010	.625			
	.550	+/- .010	.547			
	.150	+/- .010	.150			
	.750	+/- .010	.750			
SIDE B	.625	+/- .010	.627			
	.250	+ .010 - 0.0	.253			

Measured by: <i>RD</i>	Audited by: <i>RD</i>	Prototype Approval:	N/A
Date: 05/07/17	Date: 08.06.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

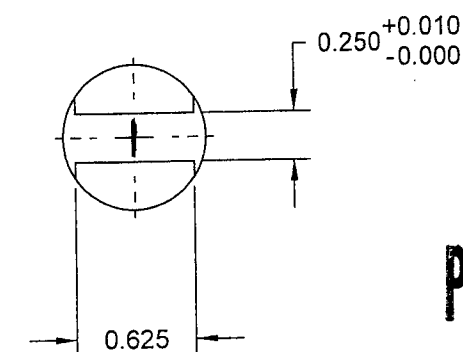
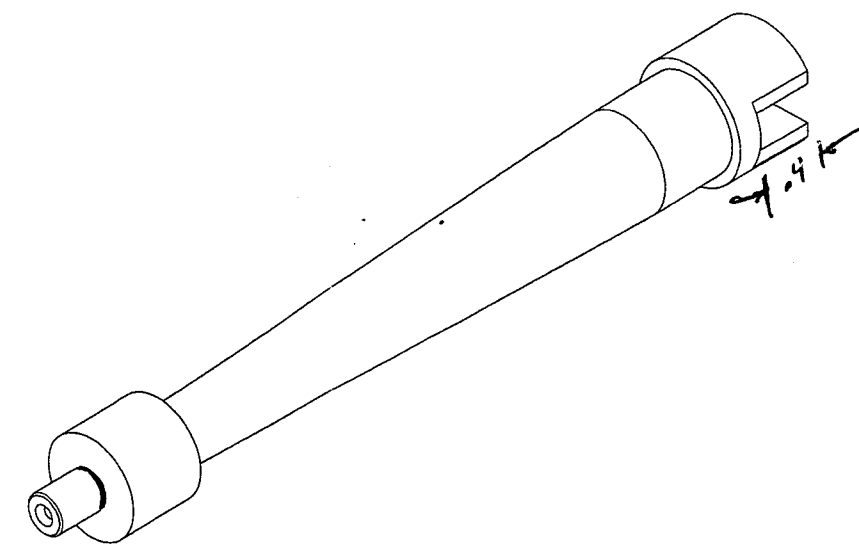
8 7 6 5 4 3 2 1



D3803-1 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs



PRELIMINARY ISSUE
AJS 08.07.08

Wb 40403

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3803	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		(204/205/212/412)	NTS
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